

Work Order ID 98110

March-06-13 1:45:46 PM

98110

Page 1

Item ID: D6020-160

Accept

N9000040100

Setup Start *NS1*

Revision ID: PRELIM

Stop *NS2*

Item Name: Crosstube Material

Start Date: 3/06/13 Start Qty: 20.00

20

Cust Item ID:

Required Date: 3/06/13 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D6020

pa3

110

0.00

110

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O:

Manufacture as per dwg D6020

120

Receive & Inspect for Damage & Mat'l Certs

0.00

120

Packaging

Memo

0.00

Packaging

Ensure material certification is attached

130

QC6- Inspect dimensions to drawing

0.00

130

QC

Memo

0.00

Quality Control

Ensure Material certification comply to Dwg

inspect parts only
see inspection sheet
DASIA
16
3-8-13/3/4

insin Finish - Poor!
unable to ultra sound

140 cross tube - drill 1/4" hole for tooling at one end

TW 13-03-06 (5)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
---	---	--

Work Order ID 98110

98110

Page 2

March-06-13 1:45:46 PM

Item ID: D6020-160 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: PRELIM Stop ***NS2***
 Item Name: Crosstube Material
 Start Date: 3/06/13 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 3/06/13 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Outsource process - Heat Treat	0.00							
140									
Outsource1	Memo	0.00							
Outsource process - Heat Treat	Issue p/o: <u>19281</u>								
	Ensure Material certification								
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.00							
Packaging	Ensure Material certification								
160	QC6- Inspect dimensions to drawing	0.00							
160									
QC	Memo	0.00							
Quality Control									

PL 13-05-3 (5)

PL 13/3/25 (8)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

98110

March-06-13 1:45:46 PM

N900040100

```
Setup  Start  *NS1*
        Stop  *NS2*
```

Start Date:	3/06/13	Start Qty:	20.00	*20*
Required Date:	3/06/13	Req'd Qty:	20.00	*20*

Cust Item ID:
Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

W1305.02

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
---	---	---	--	---



Sede Legale: 23018 TALAMONA (SO) - Via Chini Battista, 60 - C.P. 43
Tel. (0342) 67.41.11 (8 linee) - Fax (0342) 67.04.00
Indirizzo Internet: <http://www.siderval.it>
<http://www.siderval.com>
E-mail: siderval@siderval.it
Capitale Sociale € 2.860.000 int. versato
Società soggetta a direzione e coordinamento di
Calvi Holding Srl di Merate (Lc)
R.I. Sondrio, C.F. e P.IVA 00072570146 - REA 25414

Amministrazione:
25047 BOARIO TERME (BS)
Viale A. Manzoni, 23
Tel. (0364) 53.42.47
Fax (0364) 53.45.25



SPECIAL STEEL PROFILES

EXPORT INVOICE

23018 Talamona, 15/02/2013

ID NR. IT 00072570146

FATTURA N. / Invoice No. / Rechnung / Facture 456/2013		D.D.T. N. 369	
15/02/2013		15/02/2013	
N. CONFERMA / Sales conf. No / AB. Nr. / Conf. de vente 1448-2 DEL 21/11/2012		CODICE FISCALE / PARTITA IVA *non comun.*	
ORDINE / Order / Bestellung / Commande PO15494		PAGINA / Page / Seite / Page 1	RAPP. 20
DATA ORDINE 15/11/2012	SPEDIZIONE / Transport / Versand / Expedition BY AIR		
RESA / Delivery / Lieferung / Rendue DAP HAWKESBURY, ON K6A 1K7		CODICE CLIENTE 70.0013	
PAGAMENTO / Payment terms / Zahlung / Paiement 30 days from mat.recept.			
BANCA D'APPOGGIO / Bank / Bank / Banque 1			

SPETTABILE
DART AEROSPACE LTD.

**1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA**

DESTINAZIONE / Delivery address / Versandanschrift / Destination

**DART AEROSPACE Ltd.
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA**

CONTATTO



**MRS.LINDA LACELLE
+1 613 632 9577
+1 613 632 1053**

POS.	DESCRIZIONE / DESCRIPTION / BESCHREIBUNG / DESCRIPTION	PROF. NR.	N. pezzi No. pieces Stuckzahl Nr. pieces	Quantità Quantity Menge Quantite Kg.	Prezzo / Price Preis / Prix	U.M.	Importo / Amount Betrag / Montant USD
1	SPECIAL HOT EXTRUDED TUBE IN SS.17-4-PH as ASTM A564 acc.to our Dwg.PRE/12829 of 09/11/12, Nr.20 straight bars in C/L of 159"+4"/-0" Ø 3.289" x 0.444" Ref.D6020-159 Ln.1 TARIFFA DOG.: 72.22.40.10	5256	20	1.598	2.568,00	PZ	51.360,00
2	AIR FREIGHT COSTS =====	9909	1		7.900,00	PZ	7.900,00
	MATERIAL MADE IN ITALY =====						
	GROSS WEIGHT KG.1712 NET WEIGHT KG.1598 NR.1 WOODEN BOX DIM.650X500X4200 MM. =====						
	COMPLETE shipment P.O. n. PO15494						

Mod. SPED 1 Rev. 1 - 26.03.01

IMP. NON SOGG. USD	IMP. ESENTE USD	IMPONIBILE USD	I.V.A. USD	IMPONIBILE 21% USD	I.V.A. 21% USD	TOTALE FATTURA / TOTAL AMOUNT ENDBETRAG / MONTANT TOTAL
						USD
						€

CONDIZIONI GENERALI DI VENDITA - La merce viaggia a rischio e pericolo del committente anche se spedita franco destino - Trascorsi dieci giorni dal ricevimento della merce non si accettano reclami di sorta - Per ogni contestazione il Foro competente è quello di Sondrio - Trascorso il termine convenuto per il pagamento, decorrono gli interessi di mora ai sensi di legge - Per tutte le altre CONDIZIONI di vendita valgono quelle sottoscritte dal Committente nella nostra conferma d'ordine.

 Via Chini Battista 60 - 23018 Talamona (SO) Tel. (0342)674111 - Fax (0342)670400		Sistema di gestione per la qualità certificato UNI EN ISO 9001:2008. / Quality Management System UNI EN ISO 9001:2008															
		Certificato di collaudo Inspection certificate: EN10204 3.1						No.: 12 144801 1			Date: 15/02/13						
		Norma di controllo Regulations, Technical Requirements, Standards, Norms and Specifications: ASTM A 564															
Cliente / Besteller / Customer / Client DART AEROSPACE LTD. CANADA				Ordine N° / Bestell-Nr. / Order No. / Commande N° PO15494				Commessa N° / Werks-Nr. / Job No. / N° d'usine 1448.2				Profilo / Profile P. 05256		Materiale / Werkstoff / Material / Matière 17-4-PH(H1100)		Lotto / Menge / Lot 12/3217	
Note: DRAWING PRE/12829 KG.1598 20 BARS																	
Marcatura Kennzeichnung / Markings / Marquage				Dimensioni Abmessung / Size / Dimension													
Stato di fornitura: Lieferzustand / Supply condition / Etat de livr.				Normalizzato °C: Normalgeglüht / Normalized / Normalisé				Ricotto °C: Geglüht / Annealed / Recuit				Solubilizzato a °C Lösunggeglüht / Solution annealed / Tempré a l'eau					
Composizione chimica / Chemische Zusammensetzung / Chemical analysis / Composition chimique (%)																	
Fornitore: Hersteller:		Colata N° Schmelze Nr.		C	Mn	Si	P	S	Cr	Mo	Ni	Nb	Cu	N			
Supplier:		Cast No.		min					15,000		3,0000		3,0000				
Fournisseur:		Coulée Nr.		max					17,500		5,0000		5,0000				
AUBERT & D		U1118		0,0700	1,0000	1,0000	0,0400	0,0300	15,610	0,1400	4,2900	0,203	3,17	0,0300			
Trazione / Zugfestigkeit / Tensile test / Traktion (DIN EN 10002-1, DIN EN 10002-5)																	
Prova		Dimensioni Dimensionen / Dimensions		Temp.		Limite di elasticità Streck-/dehngrenze / Yield point-Proof stress / Limite élastique		Carico di rottura Zugfestigkeit / Tens. Strength / Rupture		Allungamento Bruchdehnung / Elongation / Allongement		Strizione Brucheinschnürung / Reduction / Striction		Resilienza (DIN EN 10045-1) Kerbschlagzähigkeit / Impact strength / Resilience		Durezza (DIN EN ISO 6506-1) Hardness	
Probe test essai		(mm)		(°C)		Rp 0.2 (MPa)		ReH (MPa)		Rm (MPa)		A (%)		Z (%)		L ISO-V (J)	
				+20		795		965		14		31					
1		10 X 12.5		+20		895		966		19.4		68.1					
Note:																	
Timbro del produttore Zeichen des Lieferwerks/Stamp of the works/Timbre du prod.																	
 RESPONSABILE QUALITÀ Raimondo Marcell																	
Checked:																	



Sede Legale: 23018 TALAMONA (SO) - Via Chini Battista, 60 - C.P. 43
Tel. (0342) 67.41.11 (8 linee) - Fax (0342) 67.04.00
Indirizzo Internet: <http://www.siderval.it>
<http://www.siderval.com>
E-mail: siderval@siderval.it
Capitale Sociale € 2.860.000 int. versato
Società soggetta a direzione e coordinamento di
Calvi Holding Srl di Merate (LC)
R.I. Sondrio, C.F. e P.IVA 00072570146 - REA 25414

Amministrazione:
25047 BOARIO TERME (BS)
Viale A. Manzoni, 23
Tel. (0364) 53.42.47
Fax (0364) 53.45.25



SPECIAL STEEL PROFILES

EXPORT INVOICE

23018 Talamona, 15/02/2013

IG NR. IT 00072570146

FATTURA N. / Invoice No. / Rechnung / Facture 456/2013		D.D.T. N. 369	
15/02/2013		15/02/2013	
N. CONFERMA / Sales conf. No / AB. Nr. / Conf. de vente 1448.2 DEL 21/11/2012		CODICE FISCALE / PARTITA IVA *non comun.*	
ORDINE / Order / Bestellung / Commande PO15494		PAGINA / Page / Seite / Page 2	RAPP. 20
DATA ORDINE 15/11/2012	SPEDIZIONE / Transport / Versand / Expedition BY AIR		
RESA / Delivery / Lieferung / Rendue DAP HAWKESBURY, ON K6A 1K7		CODICE CLIENTE 70.0013	
PAGAMENTO / Payment terms / Zahlung / Paiement 30 days from mat.recept.			
BANCA D'APPOGGIO / Bank / Bank / Banque			

*continued

SPETTABILE
DART AEROSPACE LTD.

**1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA**

DESTINAZIONE / Delivery address / Versandschrift / Destination

**DART AEROSPACE Ltd.
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA**

CONTATTO

**MRS.LINDA LACELLE
+1 613 632 9577
+1 613 632 1053**

POS.	DESCRIZIONE / DESCRIPTION / BESCHREIBUNG / DESCRIPTION	PROF. NR.	N. pezzi No. pieces Stückzahl Nr. pieces	Quantità Quantity Menge Quantité Kg.	Prezzo / Price Preis / Prix	U.M.	Importo / Amount Betrag / Montant USD
	WOODEN BOX NON IMP.ART.8,P.A-NON RES OPERAZIONE NON IMPOSSIBILE QUALIFICAZIONE AC1 PRODOTTI 1° SCELTA COME DA DEF.CIRC. 20/87 DEL 14/05/87 MERCE DESTINATA ALL'ESPORTAZIONE =====		NR. 1				Tot.peso: 1.598
	PAYMENT WIRE TRANSFER =====						

Personal data Protection - Law n. 196/03

Pursuant to art. 13 of Italian Legislative Decree no. 196 of 30th June 2003, entitled "Personal Data Protection Law", we inform you that we shall process your general and tax data, as well as data of an economic nature that is necessary to perform the current or future contractual relations with your company. Your data shall be treated in relation to the contractual requirements, and the fulfillment of the legal and fiscal obligations. The data shall be processed by the use of instruments and procedures that are suitable to guarantee security and confidentiality and shall be performed on both paper and computer support. We would like to remind you that you can exercise the rights outlined in art. 7 of the Consolidated Act contacting us.
The Data Controller is Siderval S.p.A., Chini Battista street, 60 - 23018 Talamona (So).

IMP. NON SOGG. USD	IMP. ESENTE USD	IMPOSSIBILE USD	I.V.A. USD	IMPOSSIBILE 21% USD	I.V.A. 21% USD	TOTALE FATTURA / TOTAL AMOUNT ENDBETRAG / MONTANT TOTAL
59.260,00						USD 59.260,00
						€ 44.466,12

BANK BCA POP.SONDRIO-BOARIO T.(BS) NR.CONTO VARUS0002558
SWIFT : POSOIT22
IBAN IT33Y0569654440VARUS0002558

CONDIZIONI GENERALI DI VENDITA - La merce viaggia a rischio e pericolo del committente anche se spedita franco destino - Trascorsi dieci giorni dal ricevimento della merce non si accettano reclami di sorta - Per ogni contestazione il Foro competente è quello di Sondrio - Trascorso il termine convenuto per il pagamento, decorrono gli interessi di mora ai sensi di legge - Per tutte le altre CONDIZIONI di vendita valgono quelle sottodescritte dal Committente nella nostra conferma d'ordine.



Spett.le Ufficio Dogana Di Competenza

OGGETTO: DICHIARAZIONE DI LIBERA ESPORTAZIONE

Consapevoli di assumere ogni conseguente responsabilità, siamo a dichiararvi che tutto il materiale esportato con Ns. fattura N. 455/2013+456/2013 con destinazione USA
Non è vincolata a licenze di esportazioni e quindi:

- **non rientra nell'elenco dei beni come da regolamento (CEE) n.1183/2007** del consiglio del 18 settembre 2007, che modifica e aggiorna il Regolamento (CE) n.1334/2000 che istituisce un regime comunitario di controllo delle esportazioni di prodotti e tecnologie a duplice uso (DUAL USE);
- **non rientra nell'elenco dei beni come da Regolamento (CEE) n.338/97** del Consiglio del 9 dicembre 1996, relativo alla protezione di specie della flora e della fauna selvatiche mediante il controllo del loro commercio (CONVENZIONE DI WASHINGTON - CITES);
- **non rientra nell'elenco dei beni culturali come da Regolamento (CEE) n.3911/92** del Consiglio del 9 dicembre 1992, relativo all'esportazione di beni culturali;
- **non rientra nell'elenco dei beni come da Regolamento (CEE) n.1236/2005** del Consiglio del 27 giugno 2005, relativo al commercio di determinate merci che potrebbero essere utilizzate per la pena di morte, per la tortura o per altri trattamenti o pene crudeli, inumani o degradanti.

Talamona, 15/02/2013

Timbro e firma del responsabile


Via Chini Battista, 60
23018 TALAMONA (SO)
Cod. Fisc. - Part. IVA: 00072570146

SPECIAL STEEL PROFILES

Sede Legale: 23018 TALAMONA (SO) - Via Chini Battista, 60 - C.P. 43
Tel. (0342) 67.41.11 (8 linee) - Fax (0342) 67.04.00
Indirizzo Internet: <http://www.siderval.it>
<http://www.siderval.com>
E-mail: siderval@siderval.it

Amministrazione:
25047 BOARIO TERME (BS)
Viale A. Manzoni, 23
Tel. (0384) 53.42.47
Fax (0384) 53.45.25

Capitale Sociale € 2.860.000 Int. Versato
Società soggetta a direzione e coordinamento di Calvi
Holding Srl di Merate (LC)
R.I. Sororio, C.F. e P.IVA 00072570146
REA 25414





Sede Legale: 23018 TALAMONA (SO) - Via Chini Battista, 60 - C.P. 43
Tel. (0342) 67.41.11 (8 linee) - Fax (0342) 67.04.00
Indirizzo Internet: <http://www.siderval.it>
<http://www.siderval.com>
E-mail: siderval@siderval.it
Capitale Sociale € 2.560.000 int. versato
Società soggetta a direzione e coordinamento di
Calvi Holding Srl di Merate (Lc)
R.I. Sondrio, C.F. e P.IVA 00072570146 - REA 25414

Amministrazione:
25047 BOARIO TERME (BS)
Viale A. Manzoni, 23
Tel. (0364) 53.42.47
Fax (0364) 53.45.25



SPECIAL STEEL PROFILES

EXPORT

23018 Talamona, 21/11/2012

SALES CONF.NO. 1448.2		MAR	PAGE 1
ORDER PO15494			
ORDER DATE 15/11/2012	TRANSPORT BY AIR		
DELIVERY DAP HAWKESBURY, ON K6A 1K7		CUSTOMER CODE 70.0013	
PACKING WOODEN BOXES+PVC			
PAYMENT TERMS 30 days from mat.recept.			
BANK			

DART AEROSPACE LTD.

1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA

DELIVERY ADDRESS

DART AEROSPACE Ltd.
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA

CONTACT NAME

MRS.LINDA LACELLE
+1 613 632 9577
+1 613 632 1053

We confirm acceptance of your order as detailed below, subject to our attached general terms and conditions.

POS.	OUR ORDER NR.	DESCRIPTION	QUANTITY	PRICE	USD
1	14482/05256 D3R	SPECIAL HOT EXTRUDED TUBE IN SS.17-4-PH as ASTM A564 acc.to our Dwg.PRE/12829 of 09/11/12, Nr.20 straight bars in C/L of 159"+4"-0" Ø 3.289" x 0.444" Ref.D6020-159 Ln.1 Delivery time: 01/03/2013 q.tà: 1.647 TARIFFA DOG.: 72.22.40.10	PZ 20		2.568,00
2	14482/99909 D3R	AIR FREIGHT COSTS (to be determined at the time of release) Delivery time: 01/03/2013 q.tà: 1 =====	PZ 1		
		MTR: EN 10204/3.1 =====			
		DELIVERY CONDITION: - Chemical analysis: Acc.to ASTM A564 - Mechanical Test: min.yield tens.strength: 140 Ksi			

RECEIVED

DEC 03 2012

SIDERVAL S.p.A.



Sede Legale: 23018 TALAMONA (SO) - Via Chini Battista, 60 - C.P. 43
Tel. (0342) 67.41.11 (8 linee) - Fax (0342) 67.04.00
Indirizzo Internet: <http://www.siderval.it>
<http://www.siderval.com>
E-mail: siderval@siderval.it
Capitale Sociale € 2.860.000 int. versato
Società soggetta a direzione e coordinamento di
Calvi Holding Srl di Merate (LC)
R.I. Sondrio, C.F. e P.IVA 00072570146 - REA 25414

Amministrazione:
25047 BOARIO TERME (BS)
Viale A. Manzoni, 23
Tel. (0364) 53.42.47
Fax (0364) 53.45.25



SPECIAL STEEL PROFILES

EXPORT

23018 Talamona, 21/11/2012

*continued

SALES CONF.NO. 1448.2		MAR	PAGE 2
ORDER PO15494			
ORDER DATE 15/11/2012	TRANSPORT BY AIR		
DELIVERY DAP HAWKESBURY, ON K6A 1K7		CUSTOMER CODE 70.0013	
PACKING WOODEN BOXES+PVC			
PAYMENT TERMS 30 days from mat.recept.			
BANK			

DART AEROSPACE LTD.

**1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA**

DELIVERY ADDRESS

**DART AEROSPACE Ltd.
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA**

CONTACT NAME

**MRS.LINDA LACELLE
+1 613 632 9577
+1 613 632 1053**

We confirm acceptance of your order as detailed below, subject to our attached general terms and conditions.

POS.	OUR ORDER NR.	DESCRIPTION	QUANTITY	PRICE	USD
		min.ultimate tens.strength 150 Ksi Max.yield tens.strength: 160 Ksi =====			
		PAYMENT WIRE TRANSFER =====			

Personal data Protection - Law n. 196/03

Pursuant to art. 13 of Italian Legislative Decree no. 196 of 30th June 2003, entitled "Personal Data Protection Law", we inform you that we shall process your general and personal data, as well as data of an economic nature that is necessary to perform the current or future contractual relations with your company. Your data shall be treated in relation to the contractual requirements, and the fulfilment of the legal and fiscal obligations. The data shall be processed by the use of instruments and procedures that are suitable to guarantee security and confidentiality and shall be performed on both paper and computer support. We would like to remind you that you can exercise the rights outlined in art. 7 of the Consolidated Act contacting us.
The Data Controller is Siderval S.p.A., Roma street, 39/C - 23018 Talamona (So).

Yours faithfully

TOTAL AMOUNT: USD 51.360,00

Encl.

TOTAL QUANTITY: 1.648,00

SIDERVAL S.p.A.

Please return the enclosed copy to us, duly signed and approved, within 3 days. If not returned within the stipulated time we will assume that you accept the conditions as set out.



CONDIZIONI GENERALI DI VENDITA GENERAL CONDITIONS OF SALE

Mod. COM10 Rev.0 del 01/05/2011

CDZVE/ALL

Conferma di vendita

La conferma di vendita si basa sulle presenti condizioni generali che il Compratore è tenuto a leggere ed accettare. L'eventuale non accettazione va comunicata entro 3 giorni lavorativi dal ricevimento della conferma a mezzo posta elettronica, fax o posta ordinaria e può comportare la cancellazione della stessa qualora non si trovi un accordo. Decorso tale termine qualsiasi contestazione alle condizioni non verrà presa in considerazione ed eventuali richieste di annullamento ordine verranno vagliate singolarmente e saranno possibili solo a produzione non ancora avvenuta o a materia prima non ancora acquistata. Una volta scaduto il termine dei 3 giorni tutte le conferme non contestate verranno considerate approvate per tacito consenso.

La quantità riportata sulle conferme ed il corrispettivo valore sono soggetti a variazioni nell'ordine generale del +/-10% (se non indicato diversamente nella conferma), dovute alla differenza tra peso teorico (calcolabile, fisso) del materiale e peso effettivo (non calcolabile, variabile) a produzione avvenuta. La Siderval SpA non è tenuta ad informare il cliente di eventuali variazioni qualora esse rientrino nei limiti generali o diversamente pattuiti. Il Compratore dovrà effettuare i propri pagamenti basandosi sull'importo fatturato, quindi effettivo, e non su quello confermato.

Contratti

Tutti i contratti stipulati a mezzo Agenti o Rappresentanti della Siderval SpA. avranno valore solo se accettati dalla SIDERVAL SpA per iscritto, contro emissione della conferma di vendita.

Consegna

I termini di consegna riportati sulle conferme di vendita sono da considerarsi soggetti ad eventuali variazioni, siano esse dovute a causa di forza maggiore (scioperi del personale e/o dei trasporti, limitazioni di energia elettrica, calamità naturali, guasti degli impianti, ritardi di fornitura della materia prima), siano esse legate alle variabili che comporta il ciclo di produzione stesso e che non sono quantificabili a priori.

Collaudo

Il collaudo del materiale, salvo accordi diversi in fase d'ordine, ha luogo presso lo stabilimento SIDERVAL SpA di Talamona. Il prezzo del collaudo è fatturato separatamente solo quando è a carico di enti esterni richiesti dal cliente: in caso contrario è incluso nel prezzo di vendita.

Trasporti

Le condizioni di fornitura e trasporto si basano sugli INCOTERMS 2010.

A fronte di spedizioni a carico del destinatario la merce viaggia non assicurata a rischio e pericolo del Compratore; in caso di avarie, differenze di peso o altri danni imputabili al trasporto spetterà al Compratore rivolgersi al Trasportatore e rivalersi su di esso. La Siderval SPA non è responsabile di danni ed avarie emerse dopo la consegna della merce al Vettore.

Il peso valido agli effetti della fatturazione è sempre quello rilevato in partenza.

Una volta pronto il materiale il Compratore verrà informato e si dovrà procedere al ritiro entro massimo 15 giorni dalla notifica di approntamento. Decorso tale termine la Siderval SPA ha il diritto di spedire la merce con proprio trasportatore e addebitare i costi di trasporto al Compratore.

Prezzi

I prezzi sono solitamente indicati in euro (€) al, kg al netto di oneri fiscali per la merce resa franco nostro stabilimento di Talamona. Su richiesta del Compratore è possibile fatturare in € al pezzo ed € al metro. Le transazioni con Paesi esteri possono essere confermate e fatturate in valuta estera. In base alle

Confirmation of sale

The confirmation of sale is based on the general conditions which the Buyer is required to read and accept. Any non-acceptance must be notified within 3 working days of receipt of the confirmation by e-mail, fax or regular mail and it could be cancelled if there is no agreement. After that date, any challenge to the conditions will not be considered, and any requests for cancellation will be assessed individually and will only be possible if production has not yet commenced or raw material purchased. Once the deadline of 3 days all confirmations uncontested will be considered as approved.

The quantities shown on the confirmation and the related value are subject to a variation of + / -10% (unless otherwise stated in the confirmation). SIDERVAL S.p.A. is not required to inform customers of any variations if they are within the general limits or as otherwise agreed. The Buyer must make their payments based on the amount invoiced, then effective, and not on the one confirmed.

Contracts

All contracts concluded by agents or representatives of SIDERVAL SpA are effective only when accepted by SIDERVAL S.p.A. in writing, with the issue of their confirmation of sale.

Delivery

The delivery times on the confirmation of sale are given in good faith and shall be considered always as only approximate and with reservations customary in the steel industry.

Testing

Material testing, unless otherwise agreed at time of order, takes place at the plant SIDERVAL SpA Talamona. The price of testing is billed separately only when it is borne by external agencies requested by the customer: otherwise it is included in the quoted price.

Transportation

The conditions of supply and transportation are based on INCOTERMS 2010. Risk passes to the purchaser upon the transfer of the goods to the transport agent or haulier or at the latest upon the goods leaving the works or storage.

In case of shipment from the consignee the goods travel are uninsured and at the risk of the buyer; in case of failures, differences in weight or other damage caused by transportation will be up to the Buyer to contact the Carrier and claim on it. SIDERVAL S.p.A. is not responsible for damages and damages arising after the delivery of goods to the carrier. Weight will be determined by our calibrated scales. Proof of weight will be the entry in our weighing records.

Once the material is ready, the Buyer will be notified and will have to take possession within a maximum of 15 days from the notification. After that date, SIDERVAL SPA has the right to ship the material with its carrier or to place them in a secure Third Party storage at the expense of the Buyer and at the Buyer's risk, and to bill the costs of transport or storage to the Buyer.

Prices

Prices are usually indicated in Euros (€) per kg net of tax for goods delivered ex-factory Talamona. On request of the Buyer, Siderval can charge per unit in € and € per meter. Transactions with foreign countries can be confirmed and invoiced in foreign currency. Under the conditions of carriage INCOTERMS agreed, the price may or may not include transportation costs.

In case of orders received with no prior offer or contract, SIDERVAL reserves the right to check and update the price and conditions ordered by the Buyer and notify the Buyer of any amendments.



CONDIZIONI GENERALI DI VENDITA GENERAL CONDITIONS OF SALE

Mod. COM10 Rev.0 del 01/05/2011

CDZVE/ALL

condizioni di trasporto INCOTERMS pattuite, il prezzo può comprendere o meno i costi di trasporto.

In caso di ordini ricevuti senza previa offerta o contrattazione, la Siderval SpA si riserva il diritto di controllare ed eventualmente aggiornare il prezzo e le condizioni ordinati dal Compratore.

Termini di pagamento

I termini di pagamento vanno pattuiti tra Venditore e Compratore. La Siderval SpA si riserva la facoltà di incaricare soggetti preposti a fare indagini sulla situazione finanziaria e sulla liquidità dei Compratori potenziali o già acquisiti per poter definire il metodo di pagamento più sicuro ed idoneo.

Il Compratore è tenuto a pagare interamente l'importo fatturato anche in caso di contestazioni sorte a fattura già emessa. La gestione dei reclami e delle contestazioni dovrà avvenire separatamente e non dovrà in alcun modo bloccare, dilazionare o modificare i pagamenti.

Se il Compratore è vincolato a pagare anticipatamente, la Siderval SpA spedisce il materiale solo ad avvenuto pagamento.

Reclami e resi

La Siderval SpA garantisce materiale corrispondente alle caratteristiche e condizioni precisate nella conferma di vendita e sul proprio disegno, senza alcuna responsabilità dell'uso a cui viene destinato il prodotto e delle successive lavorazioni. Ogni restituzione di merce dovrà essere concordata con la Siderval SpA che vaglierà in tempi brevi le motivazioni e le necessità effettive di un rientro. Qualsiasi nota spese per correzione difetti sul materiale verrà presa in considerazione solo se dettagliata, veritiera e dimostrabile.

Il Compratore ha diritto alla compensazione solo per i reclami indiscutibili o preventivamente concordati

Imballo

I costi di imballaggio, se non fatturati separatamente a seguito accordi presi in fase di offerta, sono da considerarsi inclusi nel prezzo di vendita. E' compito del Compratore verificare quale imballo sia più idoneo al trasporto in questione e verificare la disponibilità del Venditore.

Titolo di proprietà

La merce rimane di proprietà della Siderval S.p.A. fino al pagamento dell'intera fornitura e fino alla risoluzione di ogni reclamo, in particolare quelli che riguardano il saldo dei pagamenti dovuto a Siderval S.p.A. in relazione ai rapporti intersorsi.

Foro competente

Il foro territoriale competente per ogni controversia derivante dalle vendite effettuate dalla Siderval SpA è quello di Sondrio

Terms of Payment

Terms of Payment are agreed between the Seller and Buyer.

The Buyer shall pay the full amount invoiced also in case of disputes arising on invoices already issued. The management of complaints and disputes must be made separately and shall not in any way block, delay or modify the payments.

If the Purchaser is obligated to pay in advance, SIDERVAL SpA will ship the material only after receipt of payment

The Purchaser has the right to set-off only in respect of undisputed or previously agreed claims.

Complaints and returns

SIDERVAL S.p.A guarantees the material will correspond to the characteristics and conditions specified in the confirmation of sale and on their design, without any responsibility for the use to which product is intended and subsequent processing. Any return of goods must be agreed with SIDERVAL S.p.A that it will consider in the short term reasons and the real needs of a return. Any expense for correcting defects in material will be considered only if detailed, true and provable.

Packing

The cost of packaging, if not charged separately following the agreements made during the offer shall be considered included in the listed price. It takes of the Buyer check which package is most suitable for the carriage in question and verify the availability of the Seller.

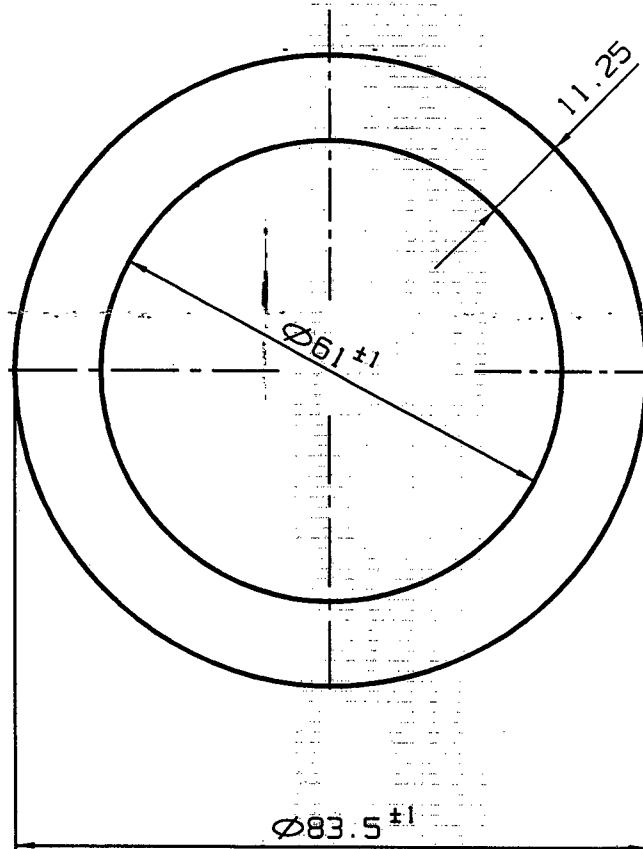
Retention of Title

All goods remain the property of Siderval S.p.A. until paid for in full and until settlement of all claims, particularly those which relate to balance of payments due to Siderval in related dealings.

Jurisdiction

The court with territorial jurisdiction for any dispute arising from sales made by SIDERVAL SpA is Sondrio.

05256

Eccentricity $\pm 15\%$

STRAIGHTNESS; 1mm/n.

SIDERVAL
s.p.a.TALAMONA
Sondrio

ITALIA

MODIFICHE

Mat: 17-4-PH

Fin. Estruso

N.p.n.

Toll. ASV/27-A

KG/n. 20.4

DIS. Nr°

PRE/12829

Scala: 1:1

Disegn.

Visto: *VR*

Data: 09-11-12

PROFILO SPECIALE

Linda Lacelle

From: Chris Provencal
Sent: March-06-13 12:36 PM
To: David Duval; Linda Lacelle
Cc: Eric Downing
Subject: D6020-PA3
Attachments: D6020-PA3.pdf

David D,

We've started working on some prototypes for 412 Hi Hi Crosstubes, which will be added to the D205-594 kits. We received from material from Siderval that needs to be heat treated. I don't have a dwg yet for the actual tube, but we need something to track the 5 pieces going out for heat treatment. Can we create a custom work order for:

D6020-160, for 5 tubes, with steps something like:

- receive / inspect from siderval, we'll attach Eric's measurements
- Drill 1/4" thru hole for tooling at one end
- Heat treat per D6020 Rev. PA3
- Receive / inspect

That way these tubes will have their own batch number, and the eventual crosstube work orders will pull those parts.

-Chris

Inspection Procedure for D412 stainless steel cross tube extrusion

TUBE # AND SIDE	Total Length	OUTSIDE DIA		INSIDE DIA		WALL THICKNESS W/MIC		CENTER OUTSIDE DIA		STRIGHTNESS @ CENTER
		HIGEST & LOWEST		HIGEST & LOWEST		HIGEST & LOWEST		HIGEST & LOWEST		HIGEST & LOWEST
1 A	162.8"	3.283"	3.270"	2.400"	2.394"	0.348"	0.340"	3.284"	3.270"	0.016"
B	1/2 = 81.4"	3.286"	3.269"	2.401"	2.395"	0.348"	0.331"			
2 A	162.8"	3.286"	3.275"	2.409"	2.402"	0.350"	0.342"	3.285"	3.269"	0.006"
B	1/2 = 81.4"	3.285"	3.271"	2.426"	2.395"	0.352"	0.336"			
3 A	162.8"	3.286"	3.269"	2.410"	2.408"	0.358"	0.342"	3.286"	3.271"	0.0105"
B	1/2 = 81.4"	3.294"	3.286"	2.395"	2.393"	0.356"	0.345"			
4 A	162.8"	3.296"	3.275"	2.401"	2.396"	0.355"	0.347"	3.289"	3.274"	0.010"
B	1/2 = 81.4"	3.291"	3.276"	2.399"	2.391"	0.361"	0.331"			
5 A	162.8"	3.281"	3.276"	2.390"	2.386"	0.356"	0.341"	3.284"	3.273"	0.011"
B	1/2 = 81.4"	3.281"	3.266"	2.407"	2.395"	0.352"	0.331"			

STRIGHTNESS @ EVERY 12"

		12"	24"	36"	48"	60"	72"
TUBE # 1	A	0.012"	0.007"	0.010"	0.0105"	0.015"	0.014"
	B	0.0105"	0.009"	0.0085"	0.011"	0.018"	0.010"
TUBE #2	A	0.0095"	0.012"	0.010"	0.011"	0.016"	0.008"
	B	0.013"	0.015"	0.014"	0.008"	0.009"	0.009"
TUBE #3	A	0.006"	0.0105"	0.011"	0.006"	0.0095"	0.019"
	B	0.016"	0.0145"	0.016"	0.020"	0.012"	0.009"
TUBE #4	A	0.005"	0.006"	0.0145"	0.0065"	0.0075"	0.0115"
	B	0.006"	0.010"	0.011"	0.0075"	0.0105"	0.006"
TUBE #5	A	0.0085"	0.006"	0.0075"	0.011"	0.014"	0.0115"
	B	0.019"	0.012"	0.0135"	0.011"	0.0195"	0.009"

WALL THICKNESS @ CENTER

TUBE #	R1	R2	R3	R4
1				
2	UNABLE TO MEASURE DUE TO TOO			
3	HEAVEY OF SCALE			
4				
5				



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO19281

Purchase Order Date 3/8/2013

PO Print Date 3/8/2013

Page Number 1 of 1

Order From :

VU-MET001

METLAB
1000 E. MERMAID LANE
WYNDMOOR, PA 19038
USA

Contact Name

Vendor Phone 215-233-2600

Vendor Fax 215-233-5653

Vendor Account Nbr

Buyer

Brigitte Golden

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	98110	D6020-160 Crosstube Material	3/22/2013 Yes	5.00	Day & Ross coll	\$730.0000	\$3,650.00

Special Inst:

Solution treat to Condition "A" ; Age harden
to Condition H-1025 to produce the
following mechanical properties: 150 KSI
UTS, Minimum, 140-160 KSI YS
Tubing with two (2) 9/16" O.D. through
holes on one end, 180° apart to allow for
hanging and vertical heat treatment.
1/2" I.D. stainless steel tubing to insert into
the end of the tube to prevent the end from
becoming oval during heat treatment.

PO Total:

\$3,650.00

Change Nbr: 1

Change Date: 3/8/2013

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required - YES NO

METLAB
1000 E. MERMAID LANE
WYNDMOOR, PA 19038

Packing List

Sales Order Number:

76339

Sales Order Date

Mar 14, 2

Page:

1

Voice: 215-233-2600

Fax: 215-233-5653

Sold To:

DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7

Ship To:

DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7

Customer ID	PO Number	Payment Terms
DARA	19281	Net 30 Days
Ship Via	Process	
OUR TRUCK		

Quantity	Item	Description	Total Shipped	This Shipment
5.00		5 PCS. CROSSTUBE D350-748-141 SOLUTION TREAT TO COND "A". AGE HARDEN TO CONDITION H-1025 TO PRODUCE MECHANICAL PROPERTIES 150 KSI UTS, MIN 140-160 KSI YS 1,200 POUNDS TOTAL		
1.00	CERT.			

COMMENTS

SHIPPED BY, SIGNATURE
METLAB

DATE

RECEIVED BY, SIGNATURE
DART AEROSPACE

DATE



1000 E. Mermaid La., Wyndmoor (Phila.) PA 19038-8093
Tel. (215) 233-2600 Fax (215) 233-5653

Certification

SOLD TO

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

March 20, 2013

Metlab Shop Order No:	76339
Purchase Order:	19281
Description:	Cross Tube
Part No.:	D350-748-141
Quantity:	5 Pieces
Weight:	1,200 Pounds
Material:	17-4 PH Stainless Steel
Specifications:	Solution treat to condition "A", age harden to condition H-1025

This is to certify that the above parts were processed as indicated above and conform to the specification requirements.

Results:

Solution annealed at 1900°F followed by age at 1025°F for 4 hours at heat

Surface Hardness: 38/40 HRC

METLAB

Quality Representative Mark Jenkins

MERCURY CONTAMINATION: During the heat treating process, testing and inspections, the product did not come in direct contact with mercury or any of its compounds nor with any mercury containing device.



Heat Treating and Metallurgical Consulting